

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012132**Date Inspected:** 07-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	NA	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	OBG and Tower				

Summary of Items Observed:

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. This QA Inspector observed the following:

OBG Trial Assembly

This QA Inspector observed ZPMC welders have left rolls of flux cored welding electrodes on two welding machines located inside the west bound cross beam side of the OBG between panel points 52 and 53. It appears that the welding machines had been used to perform splice welding of "T" stiffeners during the dayshift. No ZPMC QC Inspectors or other ZPMC workers were observed to be in the area and this QA Inspector informed dayshift Caltrans QA Inspectors' to contact dayshift ZPMC QC personnel to ensure these welding electrodes are not used for any additional welding of Caltrans materials. See the photograph below for additional information.

OBG Bays 1 through 9

This QA Inspector observed no ZPMC personnel were working on Caltrans OBG segments or tower assemblies in OBG Bays 1 through 9.

OBG Bays 13 and 14

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This QA Inspector observed no ZPMC personnel were working on Caltrans OBG segments or tower assemblies in OBG Bays 13 or 14.

Heavy Dock Tower

This QA Inspector observed ZPMC personnel have positioned a 400 ton capacity floating crane adjacent to the heavy dock and ZPMC workers are installing heavy duty rigging to one of the crane hooks in preparation for installing East tower lift 2 on top of East tower lift 1. ZPMC has installed a wooden ramp/platform which is intended to provide a cushion the bottom of the East tower lift 2 when it is moved from a horizontal position to a vertical position. Later in the shift this QA Inspector observed ZPMC has rotated the East tower lift 2 from the horizontal position to the vertical position and the East tower lift 2 is hanging from the crane hook. It appears that ZPMC intends to install this East tower lift 2 on top of East tower lift 1 during daylight hours. This QA Inspector observed no production welding taking place on any of the heavy dock tower assemblies. See the photograph below for additional information.



Summary of Conversations:

See Above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 150-0042-2372 , who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
